

Date: Thursday, 5/3/2007 11:30:08 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	: 32165		Part Number	: D2571		
Estimate Number	: 10530		Drawing Number	: D2571 REV E		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 5/3/2007	S.O. No. : N/A	Drawing Revision	: E		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 5/25/2007		
Previous Run	: 32076		Qty:	12	Um:	Each
Written By	:					
Checked & Approved By	:					
Comment	: Est: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	7075-T7351 8.25X7.75X2.5	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: <u>B25353</u>			
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: <u>B32165</u> Double check by: <u>BL</u>			
1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.			
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/06/19
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/3/2007 11:30:08 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

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Part Number: D2571

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.06.12

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MS

07-06-12

7.0 POWDER COATING

POWDER COATING



m 104144

15

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR/m/07-06-18

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



FD

07/06/18

12

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ES/07/06/18 12

10.0 QC21

FINAL INSPECTION/W/O RELEASE



12

Comment: FINAL INSPECTION/W/O RELEASE

FD/07/06/19

Job Completion



U 07/06/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: 32165				
Description: Saddle, Fwd Outboard				Part Number: D2571				
Inspection Dwg: D2571 Rev. E				Page 1 of 1				

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.745	1.748	1.746	1.747		
C	3.495	3.505		3.498	3.500	3.500	3.499		
D	1.745	1.755		1.745	1.748	1.746	1.747		
E	7.990	8.010		8.002	8.002	8.003	8.003		
F	0.490	0.510		0.497	0.499	0.499	0.503		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.496	0.501	0.501	0.502		
J	1.174	1.184		1.175	1.175	1.175	1.178		
K	0.558	0.578		0.565	0.563	0.565	0.570		
L	1.174	1.184		1.175	1.175	1.175	1.178		
M	1.490	1.500		1.495	1.494	1.495	1.494		
N	2.495	2.505		2.497	2.497	2.496	2.499		
O	3.869	3.879		3.870	3.871	3.873	3.871		
P	0.115	0.135		0.125	0.125	0.125	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.249	0.249	0.249		
S	0.115	0.135		0.126	0.129	0.127	0.131		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.232	0.234	0.237	0.239		
W	0.115	0.135		0.125	0.122	0.123	0.131		
X	0.308	0.313		0.310	0.309	0.309	0.309		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.359	0.364	0.364	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.629	0.628	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.245	0.248	0.248		
AE	1.375	1.395		1.388	1.388	1.387	1.387		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.245	0.244	0.247	0.248		
AI	2.000	2.020		2.003	2.004	2.002	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	E	Audited by:	SJ
Date:	07/06/08	Date:	07.06.08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	32165
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.439	0.439	0.439	0.439		
B	1.745	1.755		1.748	1.748	1.748	1.749		
C	3.495	3.505		3.499	3.499	3.499	3.500		
D	1.745	1.755		1.748	1.749	1.748	1.749		
E	7.990	8.010		8.000	7.999	8.001	8.000		
F	0.490	0.510		0.504	0.504	0.505	0.506		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.501	0.501	0.501	0.502		
J	1.174	1.184		1.179	1.178	1.178	1.179		
K	0.558	0.578		0.569	0.570	0.569	0.570		
L	1.174	1.184		1.179	1.178	1.179	1.179		
M	1.490	1.500		1.495	1.494	1.494	1.495		
N	2.495	2.505		2.500	2.499	2.499	2.500		
O	3.869	3.879		3.871	3.871	3.871	3.871		
P	0.115	0.135		0.124	0.127	0.126	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.249	0.248	0.248		
S	0.115	0.135		0.131	0.132	0.131	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.239	0.238	0.238	0.237		
W	0.115	0.135		0.130	0.129	0.130	0.129		
X	0.308	0.313		0.309	0.310	0.309	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.365	0.365	0.365	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.506		
AB	0.615	0.635		0.621	0.631	0.630	0.631		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.247	0.246	0.246		
AE	1.375	1.395		1.387	1.388	1.386	1.387		
AF	0.115	0.135		0.126	0.130	0.130	0.130		
AG	0.240	0.280		0.266	0.256	0.255	0.255		
AH	0.240	0.260		0.248	0.247	0.249	0.246		
AI	2.000	2.020		2.002	2.003	2.000	2.001		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	CNL	Audited by:	SD
Date:	07/06/09	Date:	07.06.12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SD

DART AEROSPACE LTD				Work Order:	32165
Description: Saddle, Fwd Outboard				Part Number:	D2571
Inspection Dwg: D2571 Rev. E				Page 1 of 1	

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				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.439	0.439	0.439	0.439		
B	1.745	1.755		1.749	1.748	1.749	1.749		
C	3.495	3.505		3.500	3.499	3.499	3.499		
D	1.745	1.755		1.749	1.748	1.749	1.749		
E	7.990	8.010		8.000	7.999	8.001	8.001		
F	0.490	0.510		0.502	0.504	0.503	0.503		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.501	0.500	0.500	0.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.569	0.570	0.570	0.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.494	1.495	1.495	1.495		
N	2.495	2.505		2.499	2.500	2.499	2.500		
O	3.869	3.879		3.872	3.872	3.872	3.872		
P	0.115	0.135		0.126	0.126	0.125	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.248	0.249	0.249		
S	0.115	0.135		0.130	0.131	0.128	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.966	2.960	2.960	2.960		
V	0.230	0.250		0.236	0.235	0.235	0.235		
W	0.115	0.135		0.127	0.129	0.129	0.129		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.766		
Z	0.352	0.372		0.364	0.365	0.364	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.632	0.632	0.631	0.632		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.244	0.245	0.245		
AE	1.375	1.395		1.388	1.387	1.388	1.388		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.245	0.245	0.247	0.245		
AI	2.000	2.020		2.002	2.001	2.002	2.001		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	<i>JW</i>	Audited by:	<i>SD</i>
Date:	07/06/10	Date:	07-06-12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JK</i> <i>SD</i>	

